

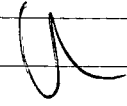
Work Order ID 126728

November-24-14 10:08:00 AM

126728

Page 1

Item ID: TESTING Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: PART FOR TESTING
 Start Date: 11/24/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/25/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan:  Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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100	0.00	DAS 07 9-89
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100
 Eng
 Engineering

Memo
 ASSEMBLE ONTO SPACEDOOR
 D412-694
 D3136-5
 D3237-1
 D3237-3
 FOR CONFORMITY TESTING

PR 1200 RTU PRIMER
 EXP. 02 SEPT 2015
 B 130 826.

DAS
07
9-89
 14/11/25

11/11/25

110	0.00	DAS 07 9-89
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110
 QC
 Quality Control

Memo
 QC/ENG APPROVAL

Dow CORNING 732.
 B 130 290.
 Exp 2015/07

DAS
07
9-89
 14/11/25

Work Order ID 126728

November-24-14 10:08:00 AM

126728

Page 2

Item ID: TESTING Accept ***N900040100*** Setup Start ***NS1***
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC21- Final Inspection - Work Order Release	0.00							
120									
QC	Memo	0.00							
Quality Control									

MF
14-12-04

November-24-14 10:07:52 AM

Work Order ID: 126728

Parent Item: TESTING

Parent Item Name: PART FOR TESTING

126728

TESTING

Start Date: 11/24/14**Required Date:** 11/25/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3136-5		Manufactured	No				Each	0.0000		1			DAS 07 9-89
D3136-5					B 126676				**				14/11/13
Spacedoor Window													DAS
D3237-1		Manufactured	No				f	196.3000		8			07 9-89
D3237-1									**				14/11/13
Seal Retainer(Price Per Sq Ft).													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				st640			196.3						
				105246			85.9						
				120345			0.8						
				121811			93						
				32825			10.1						
				60148			6.5						
D3237-3		Manufactured	No				f	794.0500		8			DAS 07 9-89
D3237-3									**				14/11/13
Seal Filler(Price Per Ft)													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				st640			794.05						
				105247			43.85						
				120466			32.2						
				121358			218						
				123981			500						

8. Reinstall and adjust D3115-1 Bracket. Reinstall D3163-041/-042 Cover Assembly.
9. Install -02 Door Assembly by repeating the above steps as for -01 assembly

3.4 Window Installation (See Figure 3)

1. Using Mylar or similar tape, carefully mask off the frame leaving an area 0.50 inches (13 mm) wide to be bonded so that adhesive and primer will not get on the surrounding areas, not intended for bonding. Helicopter paint finishes will not adhere to surfaces where silicone primer and/or adhesive have been applied.
2. Remove all adhesive from unmasked portion of window frame using stiff fiber brush and aliphatic naphtha.
3. Inspect the edge of the frame for scratches, cracks, or other damage.
4. Clean all residue from the window frame with MEK (Methyl Ethyl Ketone) and dry with a clean white cloth.
5. Apply Dow 1200 primer to area to be bonded using a small brush. Allow primer to dry between 20 minutes and one hour before bonding window seal into place.
6. Prepare D3117-1-0980 seal for bonding by abrading the narrow seal insert groove with 80-grit abrasive paper.
7. Clean all residue from the seal groove with a cloth dampened with MEK. Wipe dry with a clean cloth.

NOTE

Seal ends should meet at the 6 o'clock position.

Seal insert ends should meet at the 12 o'clock position.

8. Apply 0.010 to 0.015 inches of RTV-732 sealant to both sides of the narrow seal insert groove.
9. Apply 0.010 to 0.015 inches of RTV-732 sealant to areas of the window frame that have been prepared for bonding with Dow 1200 primer. Note: It is prohibited to bond lower corners as shown in Figure 3.
10. Do not put any adhesive in the seal groove that accepts the window. Note that the seal insert groove faces outboard.
11. Install D3117-1-0980 seal retainer in the frame. Trim as required. Masking tape may be used temporarily to hold the seal in place for the next step.
12. Place the window in the seal groove and work seal lip around the periphery of the window.
13. Install D3117-3-0980 into D3117-1-0980. Trim seal as required. Work the seal insert around until it fits properly.
14. Remove all masking tape and allow sealant to cure for a minimum of 24 hours at 75°F (24°C).
15. Reinstall trim if previously removed.
16. Each modified emergency exit should be marked. Paint a contrasting band 2" wide per FAR 29.811 if it has not already been done.

3.5 Operational Check and Adjustment

1. Ensure that D412-694-03/-04 Door Assembly is closed and latched. Place D412-694-01/-02 Door Assembly to full closed and latched position. Check that upper edge of door is parallel to top of cabin door frame.
2. If door is out of alignment, loosen screws attaching D3183-041/-042 Bracket Assembly and D3137-041 Bracket Assembly on rear edge of door. Adjust D3137-041 Bracket Assembly. Tighten attaching screws.
3. Adjust D3183-041/-042 Bracket Assembly so that roller is fully engaged in track. Tighten attaching screws.
4. Operate door through full travel while checking that all rollers on upper edge are fully engaged in track at all positions. Adjust D3121-041 Bracket assemblies as required.
5. With D412-694-01/-02 Door Assembly fully closed and latched, check that lower door track is engaged not less than 0.25 inches (6.35mm) in cabin door channel without restricting door travel through full range from closed to open positions. Be sure door track attaching screws are tightened after adjustment.
6. Operate D412-694-01/-02 Door Assembly through full travel while checking for dragging or binding. Bracket assemblies (D3121-041, D3121-043/-044, D3183-041/-042, D3137-041) are installed with

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Revision: **B**

Date: 04.10.07

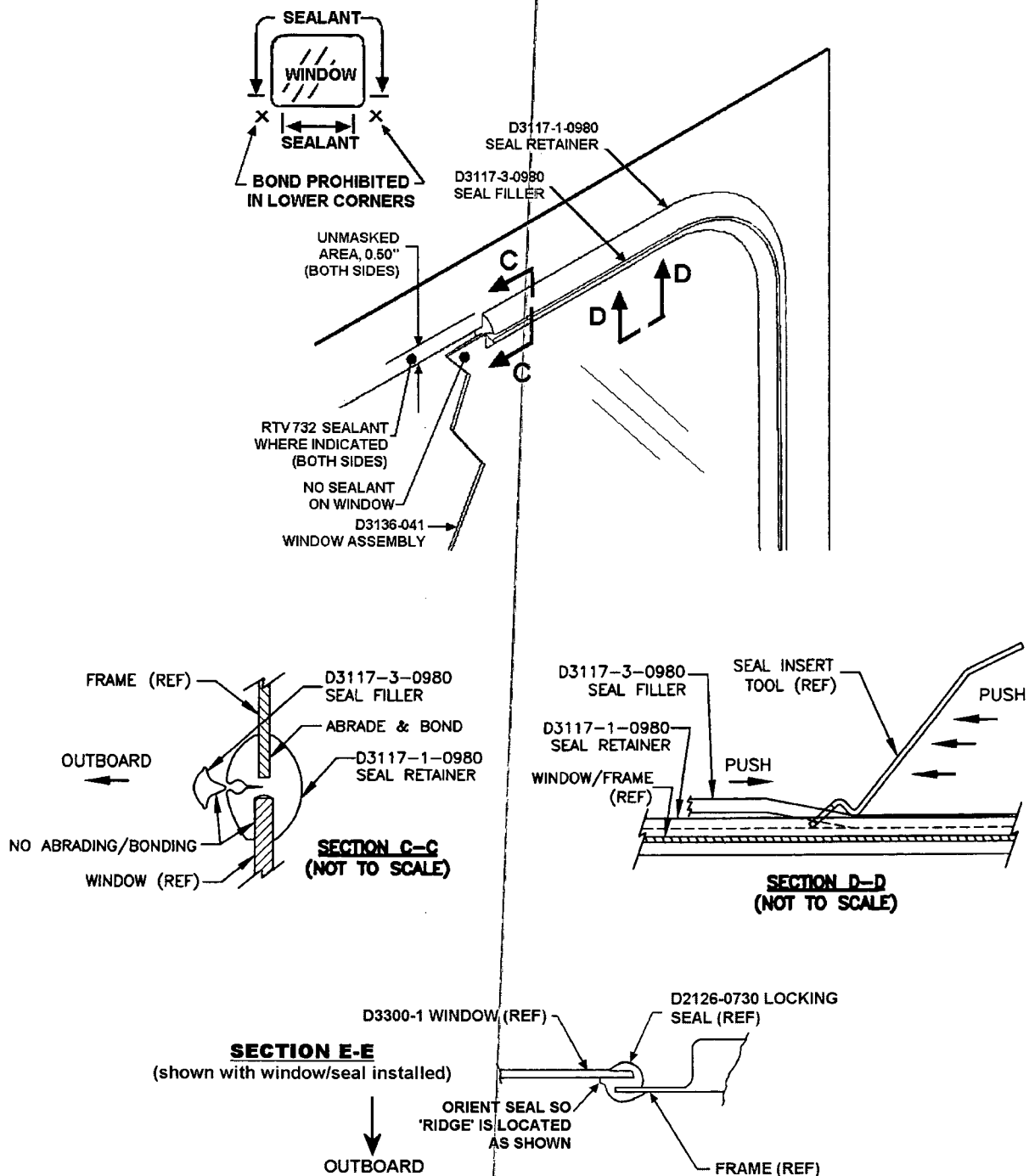


FIGURE 3: window/Seal Installation, (D412-694-01/-02 Door Assembly)

